

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014100**Date Inspected:** 01-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** You Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

Tower Trial Assembly

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 003 located on East Tower Lift-1 Bearing stiffener Plate ESD1 – SA237D/F. Welder is identified as 059525. ZPMC Quality Control (QC) Inspector is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 027 located on South Tower Lift-1 Bearing stiffener Plate SSD1 – SA18. Welder is identified as 066763. ZPMC Quality Control (QC) Inspector is identified as You Qi guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 003 located on East Tower Lift-1 Bearing stiffener Plate ESD1 – SA294F/G. Welder is identified as 070217. ZPMC Quality Control (QC) Inspector is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

(See attached photo)

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Weld joint # 061 located on South Tower Lift-1 Bearing stiffener Plate SSD1 – SA18F/G. Welder is identified as 070046. ZPMC Quality Control (QC) Inspector is identified as You Qi guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

BAY 10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005246

Magnetic Particle Testing (MT)

This QA inspector performed MT of the punch list item # 397 of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower Component. The weld designation reviewed as follows:

NORTH TOWER LIFT 4 CAPPING PLATE OF SKIN A

NSD1 – FASA4 – 1A/E – 3; 6 – Green Tag#11607

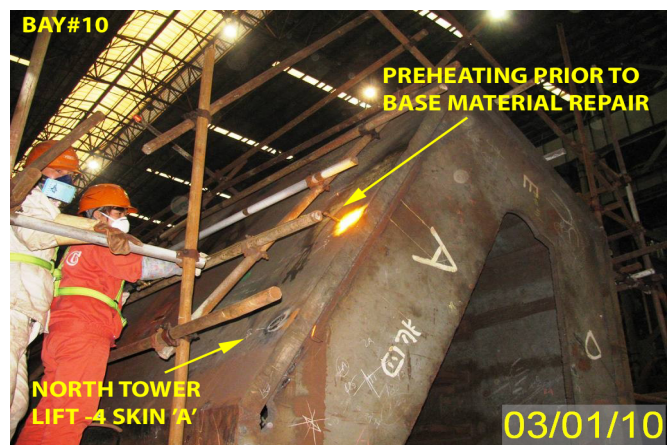
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Repair welding of base material according to the weld repair report #T-WR-3033 located on North Tower Lift-4 Skin 'A'. Welder is identified as 500363. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair – 1. (See attached photo)

Weld joint # 39B located on South Tower Lift-5 C/D corner SSD1 – TL5 – 1B – F. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U4b – 1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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